

Work Order ID 66466

Tuesday, February 15, 2011 11:26:43 AM



Page 1

Item ID: D2512

Accept



Setup Start



Revision ID:

Item Name: Basket Lid 205/350

Stop



Start Date: 2/16/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 2/28/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: 11-02-15

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2512

Rev E

100



Large Fab

Large Fab

Weld per dwg A/R S.S. rod Batch: *1119649* 0.00
Large Fab

Memo

0.00

1-Cut 3/4" x 3/4" square tubing as per Dwg D2512
2-Cut (4) D2236 From D3166-3
3-Drill holes in D2512-1 as per Dwg D2512 using Drill Jig DT8305
4-Weld as per Dwg D2512 using Welding Jig DT 9436
Deburr as required
INSTALL D2012-117 CLEVIS ONLY ON D130-701-041

11-03-10 (k)

110



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds 0.00

Memo

0.00

Pl 11-03-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Item Name: Basket Lid 205/350

Start Date: 2/16/2011 Start Qty: 1.00

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

S u l o 3 1 1 4

④

1 BR 11-3-14.

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Page 3

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Item Name:	Basket Lid 205/350				Stop	
Start Date:	2/16/2011	Start Qty:	1.00			
Required Date:	2/28/2011	Req'd Qty:	1.00			
Reference:						
				Cust Item ID:		
				Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo 1- Plug holes in D2581 and in D2327-1 bushing prior to Powdercoat M115981 1ST COAT: START TIME: 10:15 OVEN TEMPERATURE: 760° FINISH TIME: 10:45 2ND COAT: START TIME: OVEN TEMPERATURE: FINISH TIME:	0.00 0.00				1		BR 11-314	
140 HandFinish Hand Finishing	HandFinishing Memo Wing Walk and Spray Paint black as per Dwg D2512 and QSI 005 4.4 Batch: 1116402 SPRAY PAINT 1116123	0.00 0.00						1	φ 11/03/14

W/O:		WORK ORDER CHANGES						
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Picklist Print

Tuesday, February 15, 2011 11:26:35 AM

Page 1

Work Order ID: 66466

Parent Item: D2512

Parent Item Name: Basket Lid 205/350

Start Date: 2/16/2011


Required Date: 2/28/2011

Start Qty: 1.00

Required Qty: 1.00

Comments:

Rev IPP:M03.01.31 AddedD2012-117forD130-701-041KJ/RF
IPP Rev:N06.04.05 Added level21 EC
IPP REV:O ADDED D3490-1/-3 FOR D130-701-011/-043 10-04-20 JLM
VERIFIED BY:DD
IPP Rev:P 08-08-29 revE as per dwg DD verified by:EC
IPP Rev:Q 08-09-24 plug holes prior to powder coating DD verified
by:EC IPP Rev:R 10.06.29
added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2012-117 		Manufactured	No			100	Each	24.0000	2	2			

Clevis

Location

WA
55729

Loc Qty

24
24

Loc Code

1/1 350
Basket

*** ONLY APPLICABLE ON D130-701-041 -IF
NOT USED, PLEASE MARK N/A ***

D2232-1



Basket Hinge

Manufactured No

100 Each

8.0000

2

2

11-03-11

Location

WA
55791

Loc Qty

8
8

Loc Code

(2x)

D2327-1



Spacer Bushing

Manufactured No

100 Each

27.0000

2

2

11-03-11

Location

WA
60174
64899

Loc Qty

27
7
20

Loc Code

(2x)

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Page 2

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Parent Item: D2512

Parent Item Name: Basket Lid 205/350

Start Date: 2/16/2011

Required Date: 2/28/2011

Start Qty: 1.00

Required Qty: 1.00

D2506

Manufactured No

100

Each

8.0000

1

1



Label Plate



LY 11-03-11

Location

Loc Qty

Loc Code

WA

8

65279

3

65539

5

D2581

Manufactured No

100

Each

30.0000

2

2



Mounting Bracket



LY 11-03-11

Location

Loc Qty

Loc Code

WA

30

64112

7

65950

23

D3166-3

Manufactured No

100

Each

9.3804

1



Basket Hoop



SAD 11-03-09

Location

Loc Qty

Loc Code

WA

9.380371053

55697

2.1053E-05

59266

0.0418

60270

0.00265

61193

0.0416

63063

0.0522

64244

3.2421

64928

6

Tuesday, February 15, 2011 11:26:35 AM

Shop Packet Print

Page 2

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Parent Item: D2512

Parent Item Name: Basket Lid 205/350

Start Date: 2/16/2011

Required Date: 2/28/2011

Start Qty: 1.00

Required Qty: 1.00

✓ M304EX0.75-16F

Purchased

No

100

sf

957.6539

18

18.94737



Expanded Metal Flat SS

SAD 11-03-10

Location

Loc Qty

Loc Code

MAT

957.653933

114809

78.622943

114853

11.80059

115012

243.963

115401

20.6845

115989

46.5313

116178

3.0206

116508

33.3012

116768

199.7298

116795

320

18.9473

✓ M304TS0.750W.065

Purchased

No

100

f

1,322.876

43.5804

45.87411



304 SQ Tube .75x.75x.065W

SAD 11-03-10

Location

Loc Qty

Loc Code

MAT

1322.8762

112398

0

116267

322.8762

116763

1000

45.8742

Tuesday, February 15, 2011 11:26:36 AM

Shop Packet Print

Page 3

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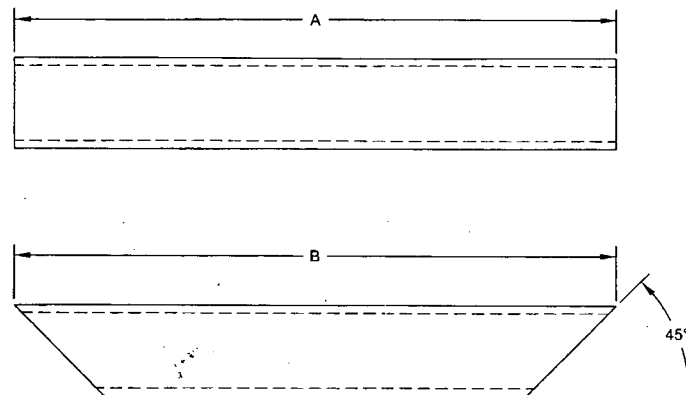
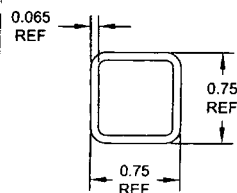
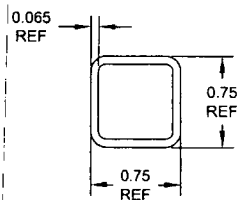
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PARTS LIST FOR D2512 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D2512-1	2	—	25.50	RIB
D2512-3	2	—	95.30	RIB
D2512-5	6	30.84	—	RIB
D2512-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRACKET



E

D2512-1/-3/-5/-7 NOTES:

- 1) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST

#06469

RELEASED
08-06-21/17

E	INCORPORATED D1 & D2 MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO 'B' FORMAT AND UPADTED TO CURRENT STANDARDS. SHT 3 VIEWS INVERTED FOR CLARITY. SHT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
DATE	08.06.17	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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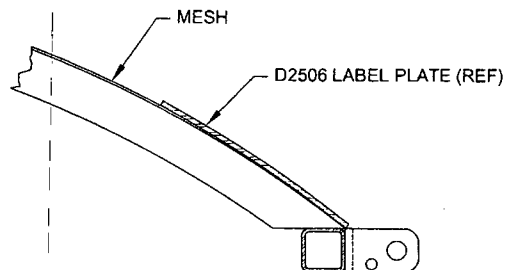
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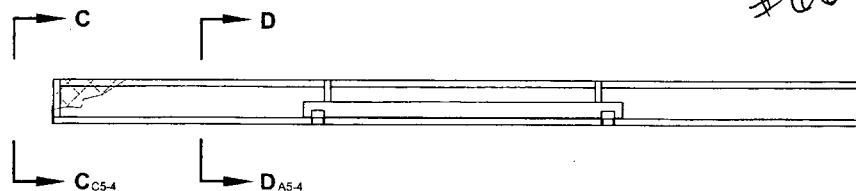
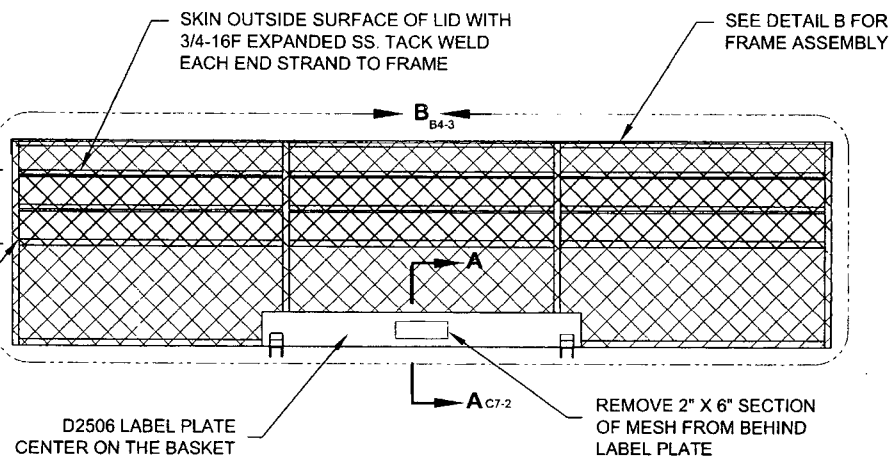
NOTE: Date & initial all entries

SECTION A-A_{B3-2}
(ROTATED 90° CCW)



FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 3
AFTER POWDER COAT.

TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKIDDED



D2512 BASKET LID ASSEMBLY NOTES:

- 1) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: N/A
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) WELD PER DART QSI 004

RELEASED
08.06.17

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID ASSEMBLY (350/212)	NTS
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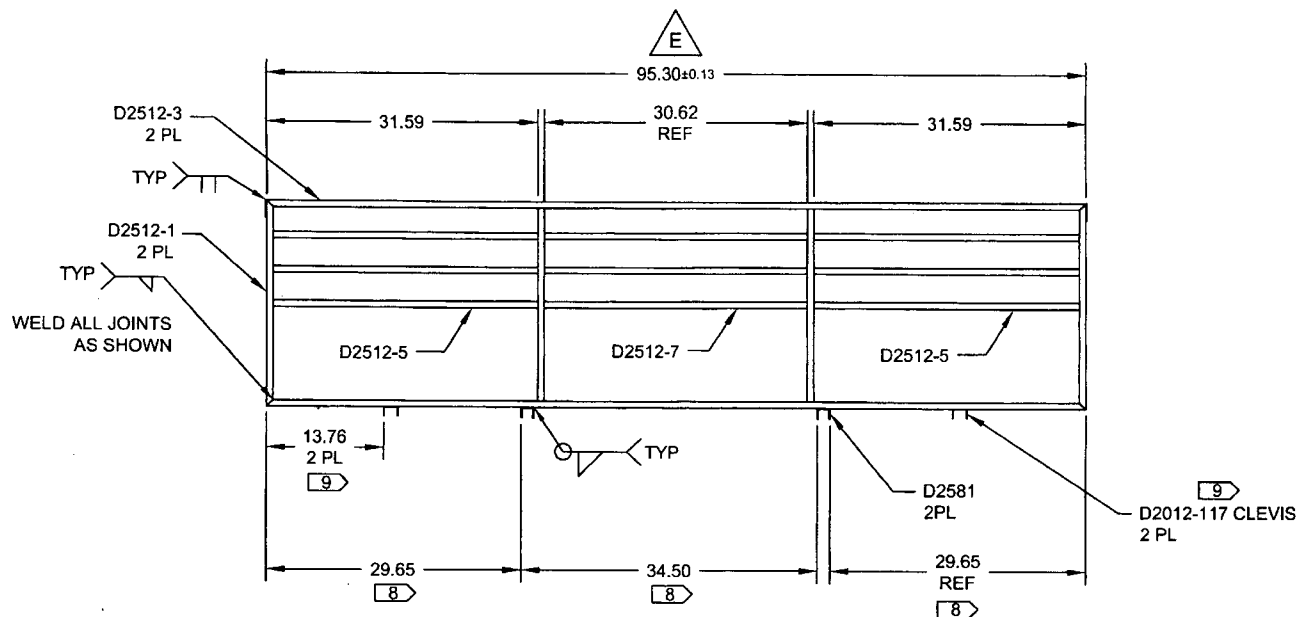
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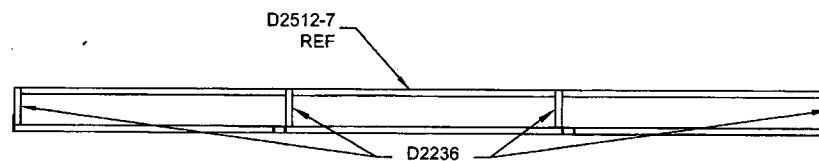
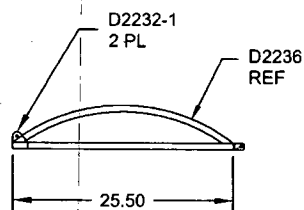
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DETAIL B C3-2
FRAMEWORK ONLY SHOWN FOR CLARITY



- NOTES:**
- 1) MATERIAL: NONE
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: N/A
 - 8) LOCATE IN CONJUNCTION WITH ADJACENT D2581 ON BASKET BASE ASSEMBLY
 - 9) FOR D130-701-041 ONLY

RELEASED
08.06.17

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DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	J	DRAWING NO.	REV. E
MFG. APPR.	D	D2512	SHEET 3 OF 4
APPROVED	AP	TITLE	SCALE
DE APPR.	H	BASKET LID ASSEMBLY (350/212)	NTS
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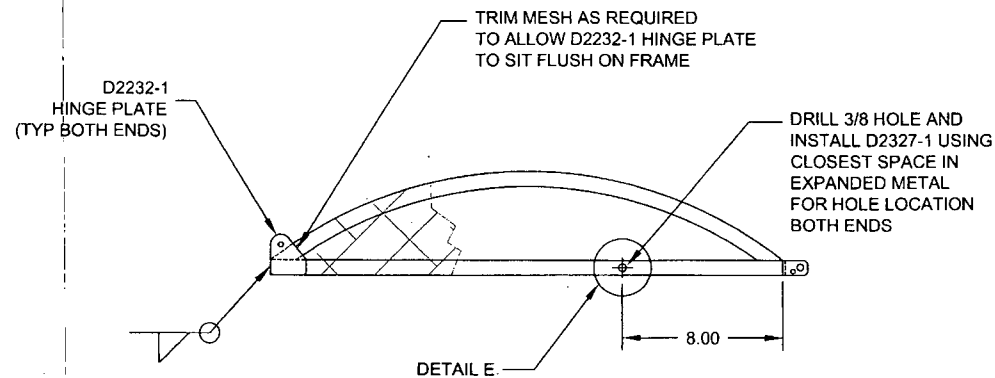
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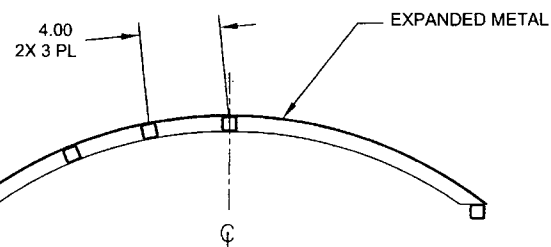
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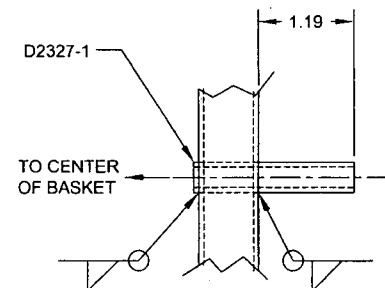
8 7 6 5 4 3 2 1



VIEW C-C SIMILAR BOTH END RIBS A5-2



SECTION D-D SAME BOTH CENTER RIBS A4-2



DETAIL E C6-4

#06466

RELEASED
08-06-17

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DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2512	SHEET 4 OF 4
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8 7 6 5 4 3 2 1

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